

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014230**Date Inspected:** 12-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Trial Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly

9AE and 9BE moved to Trial Assembly

Internal grit blasting at 7AW

This QA Inspector observed ZPMC welding personals identified as 048659 performing Shielded Metal Arc welding (SMAW) on OBE8C - 003. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) – FCM – Repair 1 and B-CWR1525

This QA Inspector observed ZPMC welding personals identified as 054467 performing Shielded Metal Arc welding (SMAW) on OBW8C – 004, 005. ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) – FCM – Repair 1 and B-CWR1525

7CW + 7DW SP CW side

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## WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welding personals identified as 045196, 066361 performing Shielded Metal Arc welding (SMAW) on 7CW – 7DW SP CB side. ZPMC QC is identified as Wu Zhi Cheng The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) – FCM – Repair 1 and B-CWR1524

(Base Metal Repair)

8AW – 8BW Transverse Splice

This QA Inspector observed ZPMC welding personals identified as 067765 performing base metal repair utilizing Shielded Metal Arc welding (SMAW) on 8AW+8BW Transverse splice deck plate. ZPMC QC is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) – FCM – Repair 1 and B-CWR1414

This QA Inspector was involved in PAUT (Phased Array Ultrasonic Testing) training for detection of cracked tacks in Deck Panels as per the following procedure “UT 04-0120F4 PJP Rib Weld Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds”

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dsouza,Christopher	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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